



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4880-041
Job Sheet 170841



Part No: D4880-041

Job Qty: 1 ea

Part Name: 206A/B FWD Leg Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/22/18

Job Tracking No:

Due Date: 2/2/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/1/18	2/1/18	0.00	0.00	Start Up Small Fab-4		FF
110	Small Fab	1 pcs	2/1/18	2/1/18	0.00	0.55	Small Fab-8		DAS FF
120	QC	1 pcs	2/1/18	2/1/18	0.00	0.00	QC5		38
130	Small Fab	1 pcs	2/2/18	2/2/18	0.00	0.55	Small Fab-8		DAS FF
140	QC	1 pcs	2/2/18	2/2/18	0.00	0.00	QC5		38
150	Outsource	1 pcs	2/2/18	2/2/18			PLP001-VC	5	9-22 10038855
160	Packaging	1 pcs	2/2/18	2/2/18	0.00	0.00	Packaging2		DAS
170	QC	1 pcs	2/2/18	2/2/18	0.00	0.00	QC5		38
180	Packaging	1 pcs	2/2/18	2/2/18	0.00	0.00	Packaging3-2		JAN 26 2018 W.K
190	QC21-SA	1 Ea	2/2/18	2/2/18	0.00	0.00	QC21		DAS 21 JAN 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4880-1	Strut	123 1 Ea (1 ea) F153891	90-Start up Operation	
D4883-7	End Fitting	124 1 Ea (1 ea) 5000471	90-Start up Operation	
D4884-1	End Fitting, Eye	124 1 Ea (1 ea) F166321	90-Start up Operation	
HL32PB5-12	Hi-Lok Pin	562 4 Ea (4 ea) 5008248	90-Start up Operation	
HL86-5	Hi-Lok Collar	562 4 pcs (4 ea) F1124822	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/22/18 2:39 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

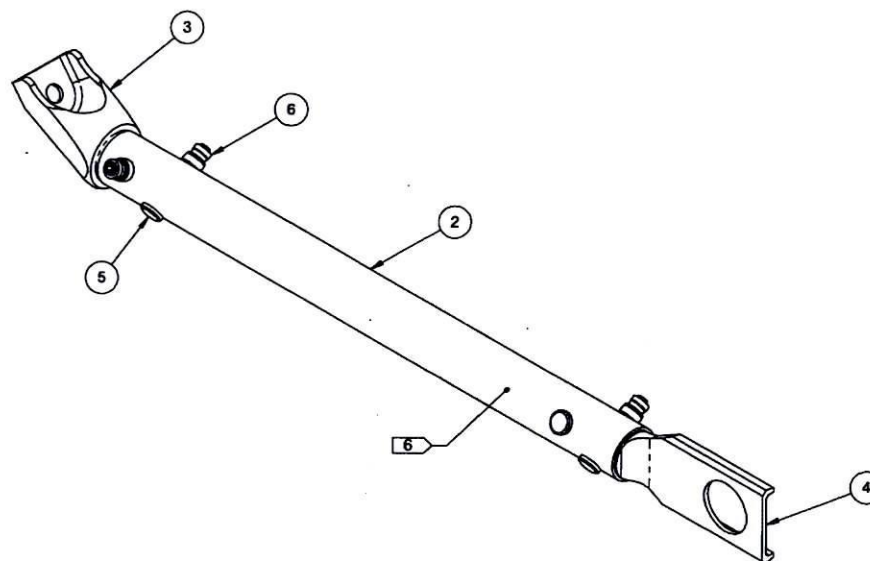
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Completed By																			
 S034445 206A/B FWD Leg Assembly, LH Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com PART NO: Original Serial #: S034445 Revision: Operation: Change No: Start up Operation 01/23/18 Job No: 170841		Lead hand / Supervisor Approval Verification																			
		QC / QA Coordinator Approval																			

Root Cause			
Environment ☐	Nc ☐	r Loss/Surge Program ☐	Positioned Wrong ☐
Design ☐	Op ☐		Outside Dimensions ☐
Doc/Data ☐	Off ☐	Stock Pulled ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Sup ☐		Part Incorrect ☐
Handling/Pre ☐	Train ☐	Out of Sequence ☐	Part Lost/Missing ☐
Material ☐	Use f ☐		Part Moved ☐
Internal Transport ☐	Poor I ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushin ☐	Mislabeled ☐	Finish ☐
LOA ☐	Produc ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		

Cut Too Short ☐	Instructions Incomplete/Unclear ☐
Drill Holes ☐	

OTHER : _____

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4880-041	FWD LEG ASSEMBLY, LH
2	1	D4880-1	STRUT
3	1	D4883-7	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4880-041 FWD LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-101-101)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.69 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9971
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9971
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

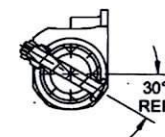
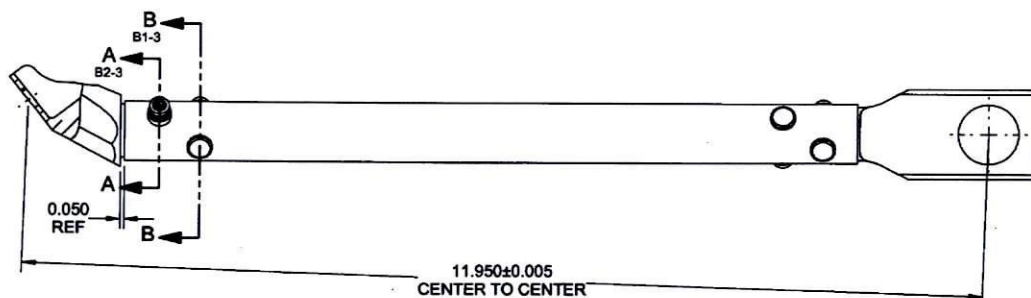
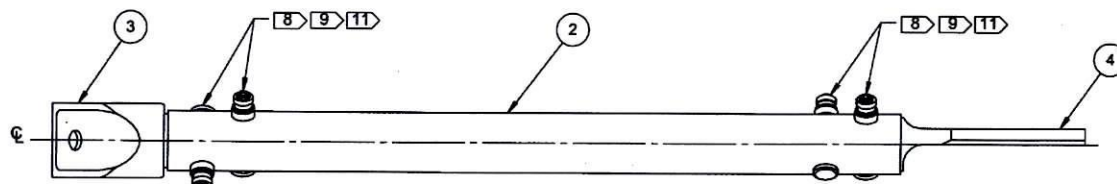
C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 8) (ZN A8-5); ADD "FWD" (ZN B4-1, B4-2, B4-3, B4-4)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS

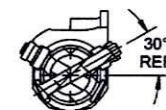
DATE **14.06.24**

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RELEASED
2014-07-03
N/A



SECTION A-A
2 PL, SIMILAR



SECTION B-B
2 PL

D4880-041 FWD LEG ASSEMBLY, LH
AUXILIARY VIEW

RELEASED
2014-07-07
WPD

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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